

Date: Monday, 2/27/2006 4:18:18 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001: Dart Helicopters Services	Drawing Name	: 206 A/B HIGH GEAR WEB
Job Number	: 25979	Part Number	: D26543
Estimate Number	: 10455	Drawing Number	: D2654 REV E1
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 2/27/2006	Drawing Revision	: E1
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 3/20/2006
Previous Run	: 25913	Unit	: Each
Written By	See Comment Below		
Checked & Approved By	JG 06.02.28		
Comment	Est Rev.D 09.02.04 Fixed typo, Changed procedure DM		

Additional Product

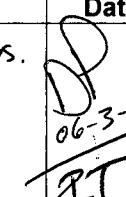
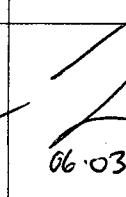
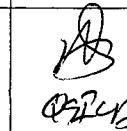
Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D26005108	Extrusion 'I Beam' thin
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2600-5 Web B24410
2.0	LANDING GEAR.1	LANDING GEAR RESOURCE 1
		Comment: LANDING GEAR RESOURCE 1 1-Cut D2600-5 to length as per Dwg D2654 BT 06-03-13(4) 2-Drill pilot holes in Web using drill jig DT 8018-3 as per Dwg D2654 BT 06-03-13(4) 3-Using the uni-bit open holes to finish size as per Dwg D2654 BT 06-03-13(4) 4-Deburr holes and ends BT 06-03-13(4)
3.0	QC5	INSPECT WORK TO CURRENT STEP
		Comment: INSPECT WORK TO CURRENT STEP DP 06-3-14(4)
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 FC 06-03-16(4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/03/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			
06-03-14	2	5 webs scrap. were cut and drilled to 02600-5 diag. Employee looked at wrong diag. -5 referenced to type of web to use.	 <u>AB</u> <u>06/03/14</u>	Scrap and clean webs. Replace. Retrain employee	 <u>BT</u> <u>06-3-14</u>	 <u>2</u> <u>06-03-14</u>	 <u>AB</u> <u>06/03/14</u>	 <u>2</u> <u>06-03-14</u>	

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B HIGH GEAR WEB

Job Number: 25979

Part Number: D26543

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 06-03-20 (4)

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 21G

BE 06-03-20 (4)

7.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/03/21 (4)

Job Completion



U 06.03.21

WORK ORDER CHANGES

W/O:		PROCEDURE CHANGE						By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector
DATE	STEP											

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE(NCR)							
DATE	STEP	Description of NC Section A	Corrective Action			Section B	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

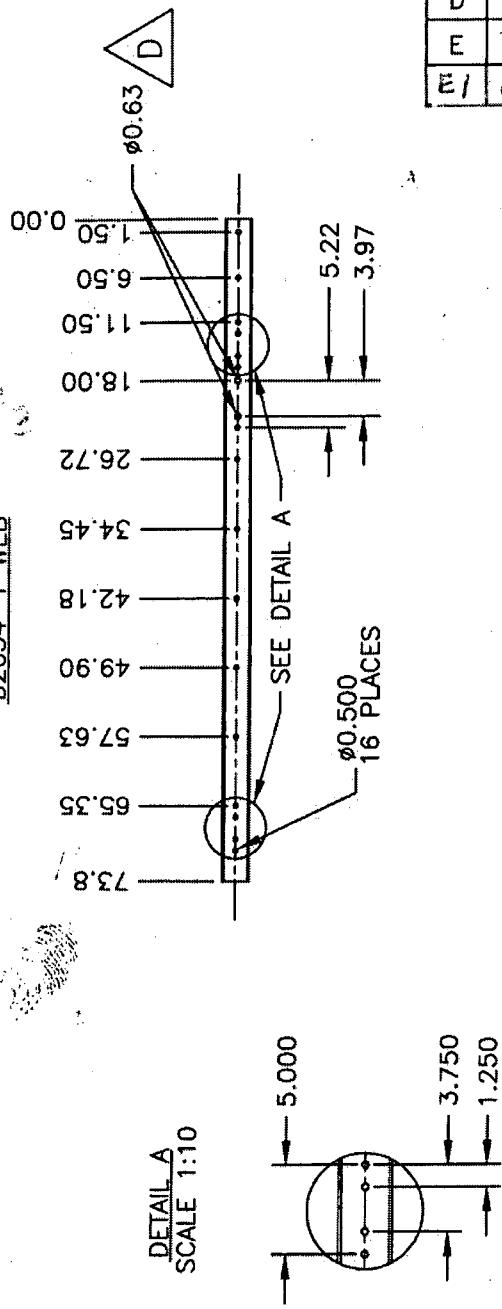
NOTE: Date & initial all entries

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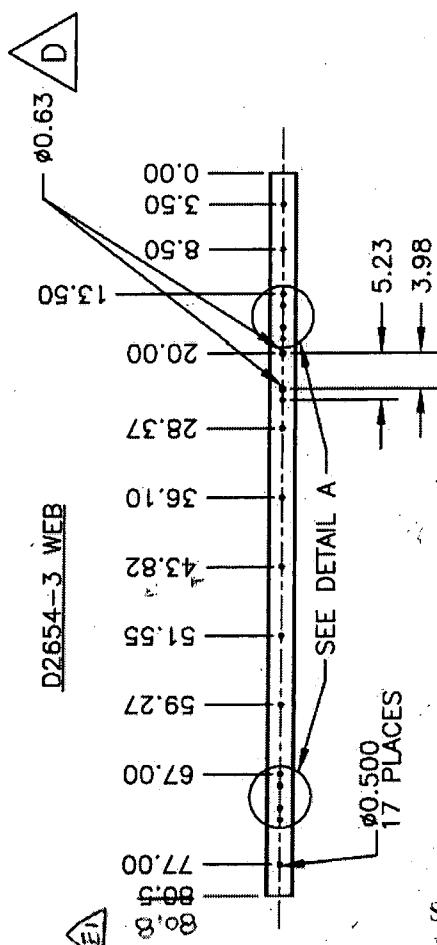
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CHECKED	APPROVED	DRAWING NO.	PORT HADLOCK, WA
		D2654	REV. E
DATE		TITLE	SCALE
04.05.26		WEB	1:20

RELEASED
04.06.22

D2654-1 WEB



D2654-3 WEB

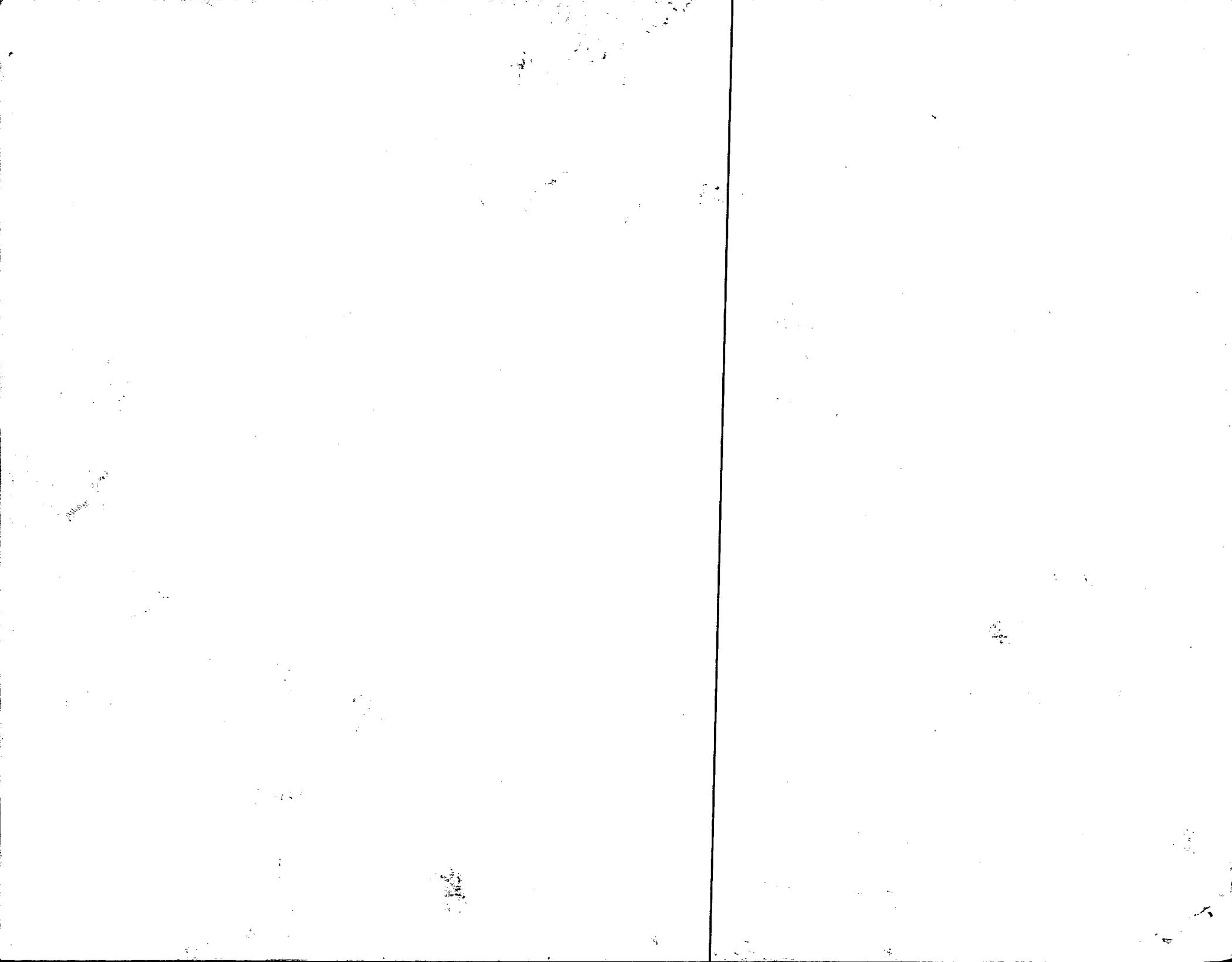


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MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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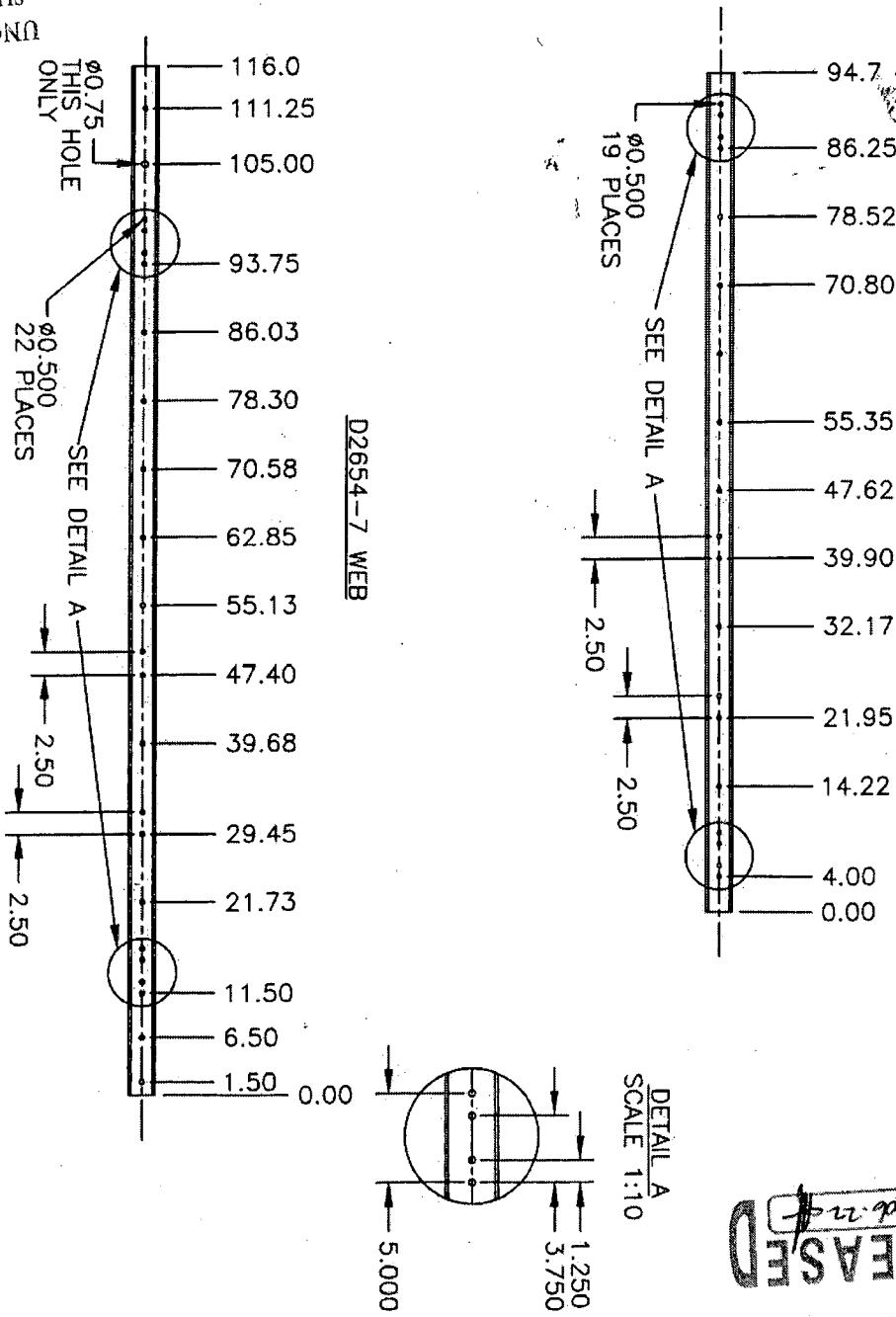


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D2654-5 WEB



MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DRAWDNG NO.	APPROVED	DATE	TIME	WEB	04-05-26	SCALE
REV. E	4	D2654	#	04-04-22-4	10:20			1:20



RELEASE

DART

